



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3393-1

Job Sheet 200385



Part No: D3393-1

Job Qty: 10 pcs

Part Name: Battery Lock Casing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/10/19

Job Tracking No:

Due Date: 10/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.02.18 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		10/8/19	0.00	0.02	Bandsaw - 1		BY 19-10-20
110	HAAS 4 Axis - B4B	10 pcs		10/8/19	0.33	5.13	HAAS - 1 - B4B		
							HAAS - 2 - B4B		BY 19/10/20
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	10 pcs		10/8/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



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CANADA
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Container No: S227417



Part: D3393-1

Job No: 200385

Serial No/Batch: S227417

Revision:

Inspector:

Print Date:

Instructions: Various STC's

Date: 10/29/19

140 Handfinish - 1-1 Chemical-B4B	10 pcs	10/8/19	0.00 0.30	QC 8 - 76	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 Powdercoat - 6 Fire Red - B4B	10 pcs	10/8/19	0.00 0.37	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
160 QC 3	10 pcs	10/8/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	

OCT 31 2019

11 205492.

START: 10:00 01/1:300' FINISIT: 10:30

RL 10-11-7

DAS
NOV 7 2019
9-89

				QC 3 - 61	
				QC 3 - 81	
170 Packaging 3-1 - Stock - B4B	10 pcs ✓	10/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
 NOV 11 2019				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	ST 501
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				180 QC 21 - SA	10 pcs ✓
				QC 21 - SA - 70	21
				QC 21 - SA - 53	53
Part Op 100 - (Bandsaw) Cut blank: 1.500" x 1.500" x 3.125" long Descriptions: 110 - (HAAS CNC Vertical Machine) Machine D3393-1 as per Folio FA510 and Dwg D3393 Identify as D3393-1 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3) START TIME: _____ 160 - (QC3- Inspect Part Finish) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6B1.500X1.500	6061-T6 Bar 1.50 X 1.50	2.7080 ft (.2708 ea)	100-Bandsaw - 1	522 53 44	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Bandsaw - 1	M6061T6B1.500X1.500	3	14	0	

MAT
used
2.645

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Battery Lock Casing	0.750Inches $\pm$ 0.010	0.760 0.740	Diameter	.752
2	Battery Lock Casing	0.625Inches $\pm$ 0.010	0.635 0.615		.626
3	Battery Lock Casing	1.250Inches $\pm$ 0.010	1.260 1.240	Diameter	1.245
4	Battery Lock Casing	1.088Inches $\pm$ 0.010	1.098 1.078		1.087
5	Battery Lock Casing	0.734Inches $\pm$ 0.010	0.744 0.724	Diameter	.738
6	Battery Lock Casing	2.658Inches $\pm$ 0.010	2.668 2.648		2.655
7	Battery Lock Casing	1.550Inches $\pm$ 0.010	1.560 1.540		1.553
8	Battery Lock Casing	0.125Inches $\pm$ 0.010	0.135 0.115		.120
9	Battery Lock Casing	45.000Degrees $\pm$ 5.000	50.000 40.000	Angle	45
10	Battery Lock Casing	1.500Inches $\pm$ 0.030	1.530 1.470		1.488
11	Battery Lock Casing	0.750Inches $\pm$ 0.010	0.760 0.740		.749
12	Battery Lock Casing	1.050Inches $\pm$ 0.010	1.060 1.040	Diameter	1.052
13	Battery Lock Casing	1.000Inches $\pm$ 0.010	1.010 0.990	Diameter	.999
14	Battery Lock Casing	0.338Inches $\pm$ 0.010	0.348 0.328		.339
15	Battery Lock Casing	0.563Inches $\pm$ 0.010	0.573 0.553		.553
16	Battery Lock Casing	0.100Inches $\pm$ 0.000 - 0.010	0.100 0.090		.098
17	Battery Lock Casing	3.000Inches $\pm$ 0.030	3.030 2.970		3.001
18	Battery Lock Casing	1.500Inches $\pm$ 0.010	1.510 1.490		1.499
19	Battery Lock Casing	0.375Inches $\pm$ 0.010	0.385 0.365		0.372
20	Battery Lock Casing	1.250Inches $\pm$ 0.030	1.280 1.220		1.247
21	Battery Lock Casing	0.125Inches $\pm$ 0.010	0.135 0.115		.120
22	Battery Lock Casing	30.000Degrees $\pm$ 0.500	30.500 29.500	Angle	30

Plex 9/10/19 3:24 PM Dart.lajeunesse.marie

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐				Date : _____ Sequence #: _____ QTY Affected : _____		MRB (QS1042)					
Description Work Order Deviation						Disposition											
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐						FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐ Pressure/Forced ☐ ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐ Other/Details: _____						Power Loss/Surge ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐ Positioned Wrong ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐					
						Completed By											
						Lead hand / Supervisor											
QC / QA Coordinator																	